

Work Order ID 63117

Thursday, October 21, 2010 1:08:29 PM



Page 1

Item ID: D4034-3

Accept



Setup Start



Revision ID:

Item Name: Rib

Stop



Start Date: 10/21/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 10/28/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10/10/21 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4034 | A |

100



Large Fab

Memo

0.00

(3)

SAO

Large Fab

1- Cut tube as per dwg D4034
2- Drill and chamfer holes as per dwg use DT9560

10-11-25

110



QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

SAO 10/11/25

(3)

120



Identify as per dwg & Stock Location: B/C

0.00

Packaging

Memo

0.00

B/C 10-11-25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 63117

Thursday, October 21, 2010 1:08:29 PM



Page 2

Item ID: D4034-3

Accept



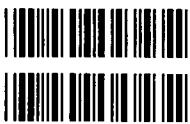
Setup Start



Revision ID:

Item Name: Rib

Stop



Start Date: 10/21/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 10/28/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

QC

Quality Control

Memo

0.00

MF

10-11-25

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NOTE: Date & initial all entries

Picklist Print

Thursday, October 21, 2010 1:08:34 PM

Page 1

Work Order ID: 63117



Parent Item: D4034-3



Parent Item Name: Rib

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304TS0.750W.049 304 SQ Tube .75x.75x.049W | | Purchased | | No | | 100 | f | 317.5950 | 1.4375 | 4.539474 | | SAP 10-11-25 | |

| Location | Loc Qty | Loc Code |
|----------|-------------|----------|
| MAT | 33.97876794 | |
| 113763 | 0 | |
| 114323 | 20.0582189 | 45294 |
| 114677 | 7.69741 | |
| 114835 | 6.223139 | |
| MAT017 | 3.68448E-05 | |
| 114298 | 3.6845E-05 | |
| WA | 283.6162 | |
| 114992 | 33.7547 | |
| 115260 | 249.8615 | |

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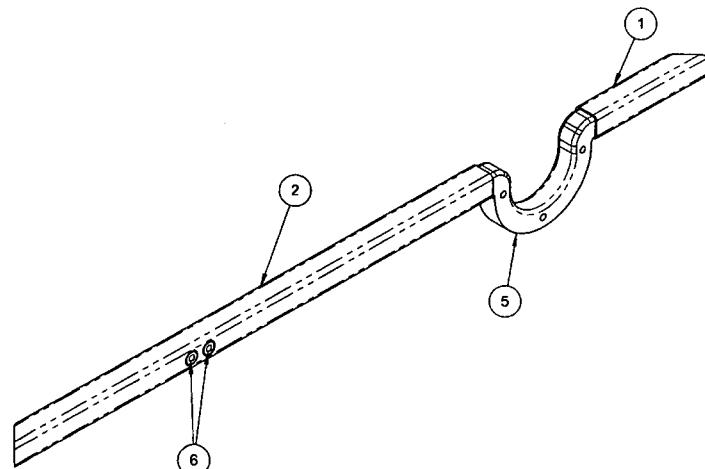
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

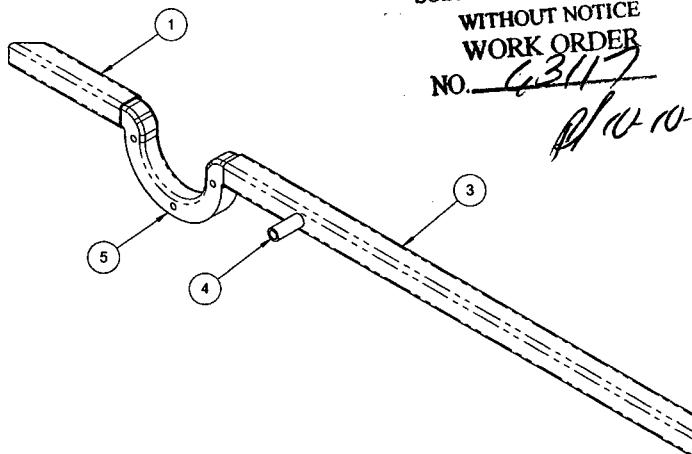
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NOTE: Date & initial all entries

| ITEM | QTY -041 | QTY -043 | P/N | DESCRIPTION |
|------|-------------|-------------|-----------|--------------------|
| | X | | D4034-041 | AFT UPPER RIB ASSY |
| | | X | D4034-043 | FWD UPPER RIB ASSY |
| 1 | 1 | 1 | D4034-1 | RIB |
| 2 | 1 | | D4034-3 | RIB |
| 3 | | 1 | D4034-5 | RIB |
| 4 | | 1 | D2327-3 | SPACER BUSHING |
| 5 | 1 | 1 | D4021-7 | HOOP |
| 6 | 2 | | D4021-9 | BUSHING |



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63117
01/03/10-21

RELEASED
2010-03-12
MW

| A | NEW ISSUE | AJS | 10.03.04 |
|-------------|-----------------------------|--------|----------|
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | | |
| DRAWN | AJS | | |
| CHECKED | <i>MM</i> | | |
| MFG. APPR. | <i>E</i> | | |
| APPROVED | <i>MM</i> | | |
| DE APPR. | <i>MM</i> | | |
| DATE | 10.03.04 | | |
| DRAWING NO. | D4034 | REV. A | |
| TITLE | UPPER RIB ASSY, BASKET BASE | SCALE | |
| NTS | | | |

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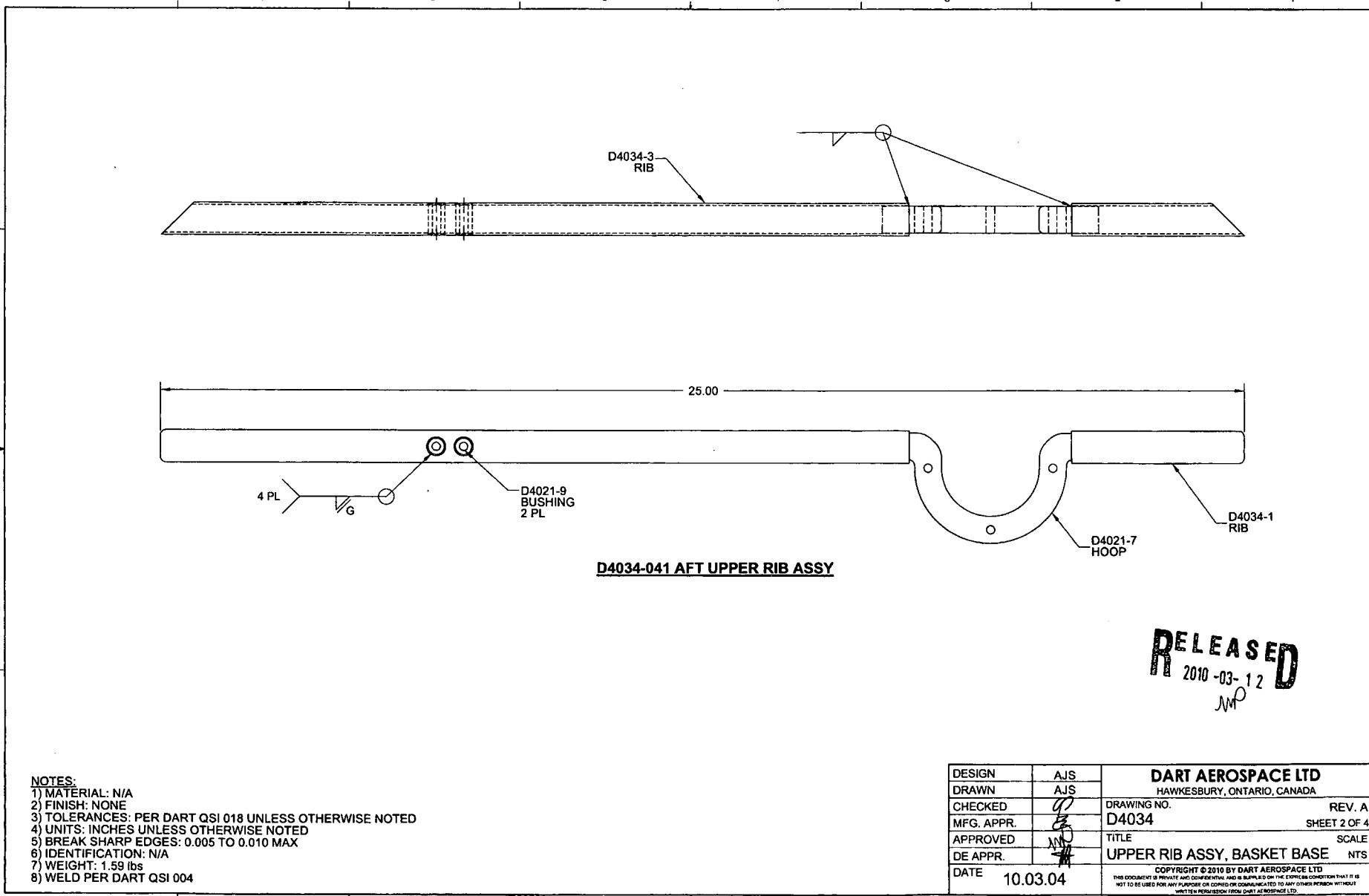
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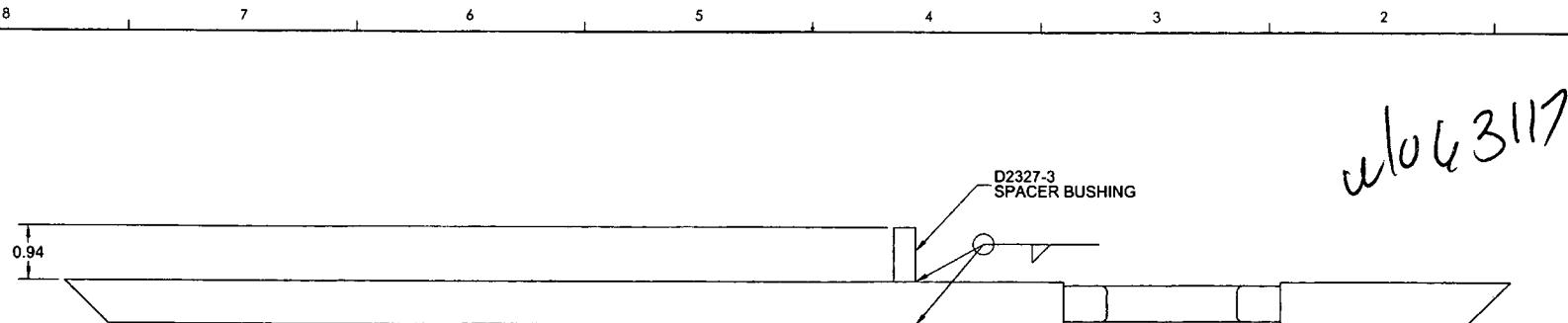
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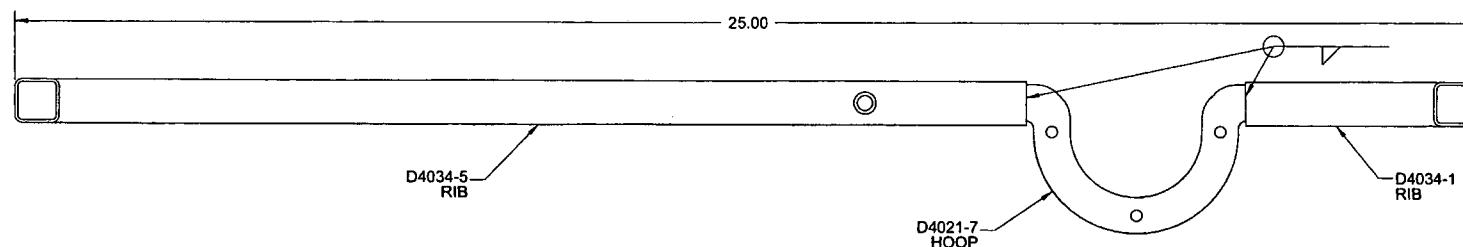
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W043117



D4034-043 FWD UPPER RIB ASSY

RELEASED
2010-03-12
AM

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.58 lbs
 8) WELD PER DART QSI 004

| | | | |
|------------|----------|--|---------------------------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>g</i> | REV. A | |
| MFG. APPR. | <i>g</i> | DRAWING NO. | D4034 |
| APPROVED | <i>W</i> | SHEET 3 OF 4 | TITLE |
| DE APPR. | <i>W</i> | SCALE | UPPER RIB ASSY, BASKET BASE NTS |
| DATE | 10.03.04 | COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT PRIOR PERMISSION FROM DART AEROSPACE LTD. | |

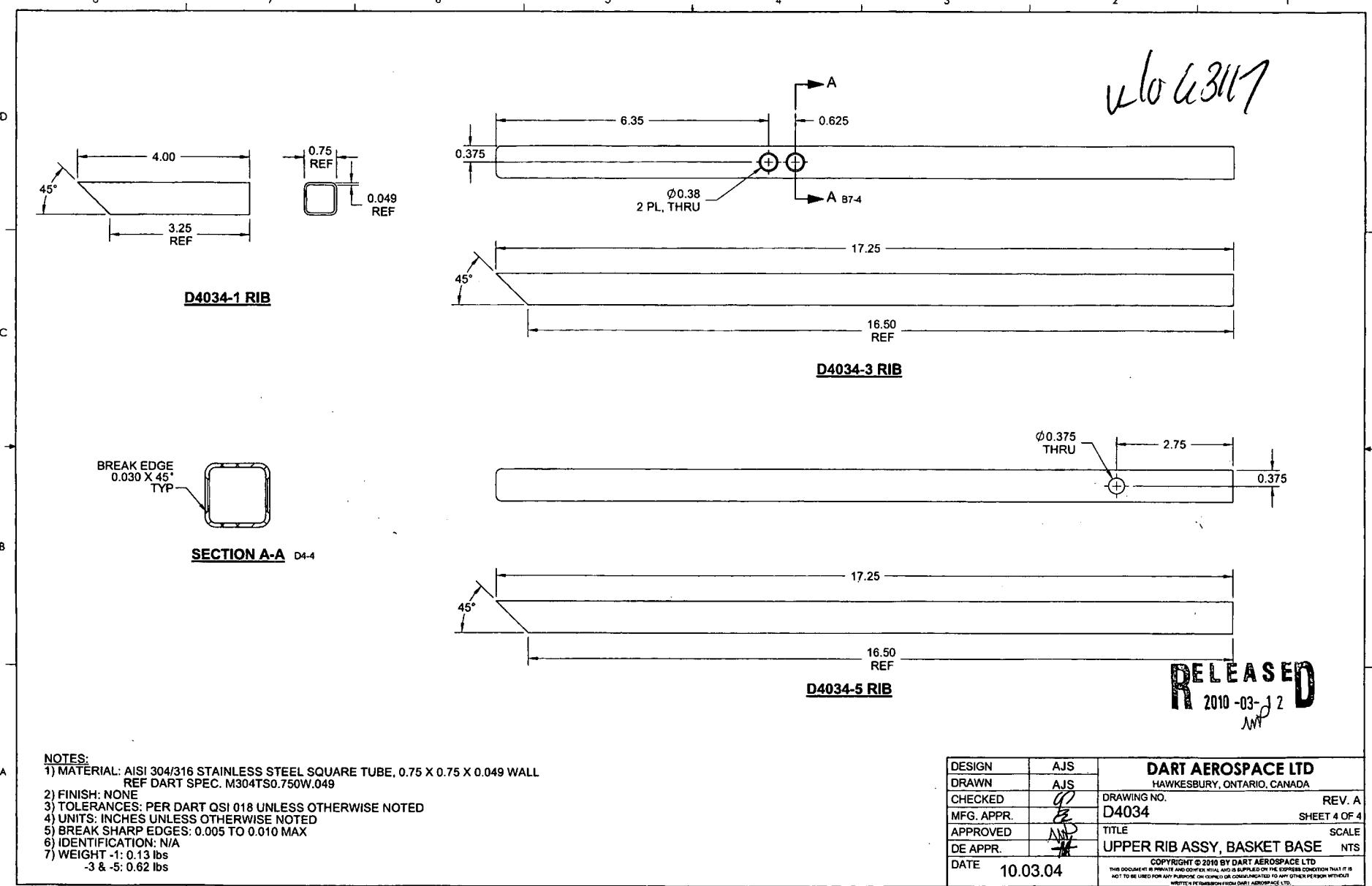
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